

Work Order ID 101203

101203

Page 1

Friday, May 03, 2013 1:27:32 PM

Item ID: D350-636-014

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Skidtube RH

Start Date: 5/3/2013 Start Qty: 1.00

1

Cust Item ID:

Required Date: 5/17/2013 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan:

Date: 12-05-3

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr |
|----------|--------------|
| D2750 | F |
| D3492 | C |

100

0.00

100

DC

DOCUMENT CONTROL

Memo

0.00

Document Control

Photocopy blue file and type labels per PPP D350-636-014 CHG 006

13.6 17

1

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Item ID: D350-636-014

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NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

110

0.00

110

Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1- Pick D2600-3 Bent

2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside AFT end per dwg D2750

3- Drill pilot holes for blade fitting bolt holes using DT8983. Open to 0.500", deburr.

4- Locate DT8329 off of blade fitting bolt holes and drill pilot holes for blade fitting

5- Drill only two fwd step holes using DT9616. Ensure proper positioning.

6- Drill pilot holes as per Dwg D2750 sheet 4 (D2750-4 details). Drill using drill Jig DT8150 & DT8864A for first side only DT8864B for second side (detail B)

7- Clecko DT8864B on second side of tube and drill pilot holes for detail B.
SECOND SIDE

8- Open up holes for SECTION BE-BE to 0.375" (2 holes per side) and blade fitting location holes to 0.500" (total of 4 holes per side) as per dwg D2750. Open holes for ground handling and detail AB to 0.500" (8 holes per side)

9-Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to 0.297".

10-Open up holes of Detail A-A to 0.297" (total of 2 holes per side)

B 13/05/15

B 13/05/30

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| | 11-Weld D2744 Cap as per.Dwg D2750 and QSI 004.Fill grooves in bend left from bending as per QSI 004 A/R Aluminum Rod batch: <i>m125127</i> | | | | | | | | |
| | 12-Grind welds flush as per Dwg D2750 | | | | | | | | |
| 120 | QC10- Inspect visual per QSI004- ground welds | 0.00 | | | | | | | |
| *120* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |
| 130 | QC5- Inspect part completeness to step on W/O | 0.00 | | | | | | | |
| *130* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

7 B2B-05-15

SWD 13.5-30 DAS 09 9-00

SWD 13.5 30

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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 140 | Chemical Conversion Coat per QS1005 4.1 | 0.00 | | | | | | | |
| *140* | | | | | | | | | |
| HandFinish | Memo | 0.00 | | | | | | | |
| Hand Finishing | | | | | | | | | |
| 150 | QC7-Inspect Chemical Conversion Coat | 0.00 | | | | | | | |
| *150* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

J.D.
SAD

①

13-05-30

D4
03

13-5-30

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Reference:

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Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

160

Skidtubes

Skidtubes

Memo

0.00

1-Open up holes section BE-BE 0.500" (4 per side) as per dwg D2750

2-Open holes section BC-BC 0.3125" (4 per side)

3-Open up holes of Detail AB and ground handling to 0.625" (total of 8 holes per side) as per dwg D2750.

4-Chamfer holes of section BE-BE, BC-BC, AB and ground handling (welding instructions on sheet 11)

5-Deburr and blow out all chips from inside of tube. Prepare tube for welding, remove alodine as required.

6-Bond web D2739 in place as per QSI 015

A/R Sikaflex-291

batch: 120493

exp. date: 13/06/22

7- Weld spacers D3490-1, D3490-5 and D2743 as per dwg D2750 & QSI004 (welding instructions on sheet 11)

A/R Aluminum Rod

batch: M125127

BE 13/06/04

8-Grind welds flush as per Dwg D2750

J. D/B 13/06/04

9-Spot face ground handling holes (total of 4 places per side) as per dwg D2750

10-Deburr holes

BE 13/05/30

BE 13/06/05

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Item Name: Skidtube RH

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Required Date: 5/17/2013 Req'd Qty: 1.00

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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--|--|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 170 *170* QC Quality Control | QC10- Inspect visual per QSI004- ground welds Memo | 0.00 0.00 | | | | 1 | | | |
| 180 *180* QC Quality Control | QC5- Inspect part completeness to step on W/O Memo ***VERIFY C'BOARD IS GOOD*** | 0.00 0.00 | | | | 1 | | | |
| 190 *190* HandFinish Hand Finishing | Pressure Wash per QSI005 4.3 Memo Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch. | 0.00 0.00 | | | | | | | |

1X of m/f 13/06/05

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Start Date: 5/3/2013 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 5/17/2013 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*

Stop *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|------------------|
| 200 *200* Powdercoat Powder Coating ml25620 | White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Memo START TIME: 7:40 OVEN TEMPERATURE: 320 °F FINISH TIME: 8:10 | 0.00 0.00 | | | | | | | 1X4 m/f 13/06/06 |
| 210 *210* QC Quality Control | QC3- Inspect Part Finish Memo Inspect for foreign object per QSI 024 | 0.00 0.00 | | | | | | | 1RH d 13/06/06 |

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Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

230

0.00

230

HandFinish

HandFinishing

Memo

0.00

Hand Finishing

1-Install inserts as per dwg D2750

2-assemble o'ring as per dwg D3492 and apply o'ring lube

A/R 55-o'ring lube batch: M121651

3-Assemble tube hardware as per dwg D2750

sikaflex batch: M1124473

4-Inspect For Foreign Objects

5-Spray inside of tube with "LPS-3" batch: M121

6-Install blade fitting D3488-041, wearshoe

SIKA FLEX 241

BATCH: M1124473EXP DATE: 1306

7-assemble o'ring to plug as per dwg D3492 and apply o'ring lube

A/R 55-o'ring lube batch: M121651

8-Coat all exposed fasteners with "LPS Procyon"

batch: M1122966101203 f 13/06/02

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N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Skidtube RH

Start Date: 5/3/2013 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 5/17/2013 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 240 | QC5- Inspect part completeness to step on W/O | 0.00 | | | | 1 | | | |
| *240* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |
| 250 | Pick Kit | 0.00 | | | | | | | |
| *250* | | | | | | | | | |
| Packaging | Memo | 0.00 | | | | | | | |
| Packaging | | | | | | | | | |
| 260 | QC4- 100% Inspect kits for completeness | 0.00 | | | | 1 | | | |
| *260* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

27
B611

13/6/17

11.11. 13-06-12 8P

27
B617

Work Order ID 101203

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Item ID: D350-636-014

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N900040100Setup Start ***NS1***

Revision ID:

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Item Name: Skidtube RH

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1

Cust Item ID:

Required Date: 5/17/2013 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

270

0.00

270

Packaging

Packaging

Memo

0.00

Packaging

Package as per PPP D350-636-014

~~12/07/12~~

Loc 072

Rev 5

13/6/17

SV

280

0.00

280

QC

QC21- Final Inspection - Work Order Release

Memo

0.00

Quality Control

MW 1306-21

R 1306-21

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

| | | | | | | | | | | | | | | | | | | |
|--|---|---|--------------------------------------|------------------------------------|------------------------------------|--------------------------------------|------------------------------------|------------------------------------|--|----------------------------------|--|------------------------------------|--|--------------------------------|------------------------------------|------------------------------------|-----------------------------------|--|
| Work Order: _____ Part No. _____ NCR No. _____ | DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/> | AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table> | Skid-tube <input type="checkbox"/> | Crosstube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> | Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coord. <input type="checkbox"/> | Quality <input type="checkbox"/> | Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> | |
| Skid-tube <input type="checkbox"/> | Crosstube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> | | | | | | | | | | | | | | | |
| Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coord. <input type="checkbox"/> | Quality <input type="checkbox"/> | | | | | | | | | | | | | | | |
| Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | | | | | | | | | | | | | | | |
| Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> | | | | | | | | | | | | | | | | |

| Root Cause | Date | Step | Qty | Description of work order update or Non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---------------|------|------|-----|---|-------------------|--------------------|-------------|--------------|--------------|
| Doc/Data | | | | | | | | | |
| Equip/Tooling | | | | | | | | | |
| Operator | | | | | | | | | |
| Material | | | | | | | | | |
| Setup | | | | | | | | | |
| Other | | | | | | | | | |
| Process | | | | | | | | | |
| Supplier | | | | | | | | | |
| Training | | | | | | | | | |
| Unapproved | | | | | | | | | |

FAULT CATEGORY

| | | |
|---|---|---|
| Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube | General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio | <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions |
| | | <input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge |
| | | <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other |

Picklist Print

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Work Order ID: 101203

101203

Parent Item: D350-636-014

D350-636-014

Parent Item Name: Skidtube RH

Start Date: 5/3/2013

Required Date: 5/17/2013

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:H02.09.25Rearranged procedure stepsKJ
 IPP Rev:I05.12.08Rearranged procedure stepsEC
 IPP Rev:J06.03.30Per rev. D EC
 IPP Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verified By:EC
 IPP Rev:M 08-09-23 revF as per dwg DD verified by:ec IPP Rev:N
 10.06.22 revise seq110 DD verf:EC IPP Rev:O 10.10.01 as
 per IIN revH DD verf:EC

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|

ALS4-1032-225

Purchased

No

230

Each

898.0000

38

38

AI S4-1032-225

Insert

AL57-1032-225

**

13/06/06

Location

Loc Qty

Loc Code

FP001

842

118386

55

118966

68

120410

10

120451

13

121269

77

122827

619

ST280

56

x38

118520

56

AN3C5A

Purchased

No

230

Each

2,765.000

34

34

AN3C5A

Bolt

**

13/06/06

Location

Loc Qty

Loc Code

FG

5

122800

5

ST350

28

116419

28

ST512

2732

124221

738

125388

1994

x34

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D350-636-014

Parent Item Name: Skidtube RH

Start Date: 5/3/2013

Required Date: 5/17/2013

Start Qty: 1.00

Required Qty: 1.00

AN3C6A

Purchased

No

230

Each

276.0000

4

4

AN3C6A

BOLT

**

11 13/06/10 6

Location

Loc Qty

Loc Code

FG

10

122416

10

FP001

30

122599

30

FP002

1

111982

1

ST351

235

122416

235

X1

AN6C44A

Purchased

No

230

Each

198.0000

4

4

AN6C44A

BOLT

**

11 13/06/10 6

Location

Loc Qty

Loc Code

FG

2

103964

2

st503

196

125389

196

X1

AN8C21A

Purchased

No

250

Each

94.0000

2

2

AN8C21A

BOLT

**

11.11.13-06-12

Location

Loc Qty

Loc Code

ST

2

123966

2

ST342

92

123642

1

123966

2

124884

41

125486

48

2X

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D350-636-014

Parent Item Name: Skidtube RH

Start Date: 5/3/2013

Required Date: 5/17/2013

Start Qty: 1.00

Required Qty: 1.00

AN8C35A

Purchased

No

230

Each

49.0000

1

1

AN8C35A

BOLT

**

13/06/09

Location

Loc Qty

Loc Code

FG

5

121275

5

FP001

2

115960

1

121275

1

st507

42

124827

42

X1

AN960C10L

NAS1149C0332

Purchased

No

230

Each

0.0000

38

38

AN960C10L

washer

D2600-3-BENT

Manufactured

No

110

Each

29.0000

1

D2600-3-BENT

Extrusion Bent

**

124580 (V38) 13/06/06

**

13/05/15

Location

Loc Qty

Loc Code

LG

29

100688

10

66875

7

73253

1

75021

1

75022

1

75023

1

81330

4

83305

1

97615

3

Picklist Print

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D350-636-014

Parent Item Name: Skidtube RH

Start Date: 5/3/2013

Required Date: 5/17/2013

Start Qty: 1.00

Required Qty: 1.00

D2739

Manufactured No

160 Each

19.0000

1 1

D2739

350 I Beam

**

B

Location

Loc Qty

Loc Code

LG

101851

19

100199

2

100235

2

100553

2

72155

1

81508

1

85487

1

87734

1

96249

2

97319

2

97618

4

98518

1

D2741

Manufactured No

250 Each

43.0000

1 1

D2741

Blade, 350 Skidtube

**

100669 *W* *58*

Location

Loc Qty

Loc Code

FG

1

85480

1

ST466

42

71856

1

85480

1

98323

40

Shp

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Page 5

Work Order ID: 101203

101203

Parent Item: D350-636-014

D350-636-014

Parent Item Name: Skidtube RH

Start Date: 5/3/2013

Required Date: 5/17/2013

Start Qty: 1.00

Required Qty: 1.00

D2743

Manufactured No

160

Each

215.0000

8

8

D2743

Crossbolt Spacer

**

BE 13/05/15

Location

Loc Qty

Loc Code

LG

1

97584

1

LG001

179

67766

4

68251

3

73403

64

74445

1

79517

2

99032

21

99785

84

LG002

35

81965

23

83262

2

85459

4

88504

2

95148

2

95901

2

D2744

Manufactured No

160

Each

103.0000

1

1

D2744

Cap

**

BE 13/05/15

Location

Loc Qty

Loc Code

LG

102

94647

2

97543

100

LG002

1

62715

1

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Picklist Print

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Page 6

Work Order ID: 101203

101203

Parent Item: D350-636-014

D350-636-014

Parent Item Name: Skidtube RH

Start Date: 5/3/2013

Required Date: 5/17/2013

Start Qty: 1.00

Required Qty: 1.00

D2745

Manufactured No

230

Each

186.0000

8

8

D2745

Bushing

**

13/06/06

Location

Loc Qty

Loc Code

FP001

10

B100991

ve

69529

1

76142

1

79518

6

83260

2

FP-001

1

92539

1

ST017

175

94715

36

95878

3

97574

120

97978

16

D3488-042

Manufactured No

230

Each

19.0000

1

1

D3488-042

Blade Fitting Assembly, RH

**

13/06/06

Location

Loc Qty

Loc Code

FP001

7

83417

1

94963

3

97026

3

FP002

12

97672

12

1

Picklist Print

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Work Order ID: 101203

101203

Parent Item: D350-636-014

D350-636-014

Parent Item Name: Skidtube RH

Start Date: 5/3/2013

Required Date: 5/17/2013

Start Qty: 1.00

Required Qty: 1.00

D3490-1

Manufactured No

160

Each

32.0000

4

4

D3490-1

Cross Bolt Spacer

**

BE 13/06/04
B100560 *4

Location

Loc Qty

Loc Code

LG001

28

62450

2

74875

4

77042

3

95977

1

97621

2

99074

16

LG004

4

81976

2

94805

2

D3490-5

Manufactured No

160

Each

34.0000

4

4

D3490-5

Cross Bolt Spacer

**

BE 13/06/04

Location

Loc Qty

Loc Code

LG

31

93834

1

97289

30

LG001

2

83373

2

LG004

1

87669

1

4

Picklist Print

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Work Order ID: 101203

101203

Parent Item: D350-636-014

D350-636-014

Parent Item Name: Skidtube RH

Start Date: 5/3/2013

Required Date: 5/17/2013

Start Qty: 1.00

Required Qty: 1.00

D3492-1

Manufactured No

230

Each

100.0000

8

8

D3492-1

Plug

**

all 13/06/06

Location

Loc Qty

Loc Code

FP001

100

B101063

Y0

69531

8

74444

2

76235

4

83098

7

88541

3

91466

2

97266

3

97595

4

98476

5

99051

2

99800

60

D3492-5

Manufactured No

230

Each

182.0000

8

8

D3492-5

Plug

**

all 13/06/06

Location

Loc Qty

Loc Code

FP001

142

87146

1

88214

81

93891

40

97039

20

FP002

40

94508

40

Picklist Print

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Work Order ID: 101203

101203

Parent Item: D350-636-014

D350-636-014

Parent Item Name: Skidtube RH

Start Date: 5/3/2013

Required Date: 5/17/2013

Start Qty: 1.00

Required Qty: 1.00

D3493-1

Manufactured No

250

Each

62.0000

2

2

D3493-1

Washer

**

11.10.13-06-12

Location

Loc Qty

Loc Code

FG

10

97201

10

ST052

52

97568

22

99009

30

2x

***ONLY INSTALL IF INSTALLING ON APICAL
FLOAT SYSTEM***

D3535-25

Manufactured No

230

Each

27.0000

1

1

D3535-25

Wearshoe

**

11.10.13-06-106

Location

Loc Qty

Loc Code

FG

2

95077

2

13100391

x1

FP002

25

100391

12

62233

1

81357

1

87385

1

90061

1

98378

9

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Work Order ID: 101203

101203

Parent Item: D350-636-014

D350-636-014

Parent Item Name: Skidtube RH

Start Date: 5/3/2013

Required Date: 5/17/2013

Start Qty: 1.00

Required Qty: 1.00

D35B6-25

Manufactured No

230

Each

25.0000

1

1

D3536-25

Gasket

**

13/06/04

Location

Loc Qty

Loc Code

FG

6

B101462

x1

87053

2

95328

4

FP001

19

100719

15

83900

1

89057

1

93696

1

95686

1

D3537-1

Manufactured No

230

Each

114.0000

3

3

D3537-1

Wearpad

**

13/06/06

Location

Loc Qty

Loc Code

FG

20

B99825

y3

79833

10

88562

10

FP001

94

83254

1

83255

3

87697

1

88562

9

91668

24

94395

1

97289

1

98494

48

98495

6

Picklist Print

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Work Order ID: 101203

101203

Parent Item: D350-636-014

D350-636-014

Parent Item Name: Skidtube RH

Start Date: 5/3/2013

Required Date: 5/17/2013

Start Qty: 1.00

Required Qty: 1.00

D3631-1

Manufactured No

230

Each

83.0000

8

8

D3631-1

Washer

**

13106106

Location

Loc Qty

Loc Code

FP001

68

13100446

x2

81874

2

83588

18

91606

1

94702

1

99002

46

FP002

15

68062

2

75548

13

D3791-1

Manufactured No

230

Each

10.0000

1

1

D3791-1

Wearplate

**

13106106

Location

Loc Qty

Loc Code

FP002

10

1399712

x1

62239

2

83392

1

97715

7

D3793-1

Manufactured No

230

Each

15.0000

1

1

D3793-1

Wearshoe

**

13106106

Location

Loc Qty

Loc Code

FP002

15

13100333

x1

82171

2

87273

3

92382

1

97080

1

98325

8

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Work Order ID: 101203

101203

Parent Item: D350-636-014

D350-636-014

Parent Item Name: Skidtube RH

Start Date: 5/3/2013

Required Date: 5/17/2013

Start Qty: 1.00

Required Qty: 1.00

D3793-3

Manufactured No

230

Each

15.0000

1

1

D3793-3

Wearshoe

**

13/06/06

Location

Loc Qty

Loc Code

FP001

1

B98289

X1

92487

1

FP002

14

95723

3

99604

11

D3794-1

Manufactured No

230

Each

25.0000

1

1

D3794-1

Gasket

**

13/06/06

Location

Loc Qty

Loc Code

FP001

25

100498

12

87631

2

92426

1

95913

1

99177

2

99375

7

D3794-3

Manufactured No

230

Each

32.0000

1

1

D3794-3

Gasket

**

13/06/06

Location

Loc Qty

Loc Code

FP001

32

100326

16

74530

2

92658

1

94544

1

99305

12

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Picklist Print

Page 13

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Work Order ID: 101203

101203

Parent Item: D350-636-014

D350-636-014

Parent Item Name: Skidtube RH

Start Date: 5/3/2013

Required Date: 5/17/2013

Start Qty: 1.00

Required Qty: 1.00

MS21043-6

Purchased

No

230

Each

336.0000

4

4

MS21043-6

NUT

**

13/06/04

Location

Loc Qty

Loc Code

FG

20

103693

20

ST315

156

117887

2

120308

14

124231

140

ST506

160

124485

160

MS21083C8

Purchased

No

230

Each

112.0000

1

1

MS21083C8

NUT

**

13/06/04

Location

Loc Qty

Loc Code

ST319

102

123900

3

125484

99

ST506

10

124308

10

MS21083C8

Purchased

No

250

Each

112.0000

2

2

MS21083C8

NUT

**

13-06-12

Location

Loc Qty

Loc Code

ST319

102

123900

3

125484

99

ST506

10

124308

10

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Picklist Print

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Page 14

Work Order ID: 101203

101203

Parent Item: D350-636-014

D350-636-014

Parent Item Name: Skidtube RH

Start Date: 5/3/2013

Required Date: 5/17/2013

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0832R

Purchased

No

230

Each

162.0000

1

1

NAS1149C0832R

WASHER

**

u 13/06/06

Location

Loc Qty

Loc Code

ST292

162

122441

162

NAS1149D0863J

Purchased

No

250

Each

956.0000

2

2

NAS1149D0863J

WASHER

**

u 13-06-12

Location

Loc Qty

Loc Code

FP001

14

118078

14

ST294

42

123900

42

st510

900

125268

600

125484

300

NAS1515H3L

Purchased

No

230

Each

497.0000

4

4

***NAS1515H3I ***

WASHER

**

u 13/06/06

Location

Loc Qty

Loc Code

FG

40

102472

40

ST297

457

121556

45

124542

412

x-1

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Work Order ID: 101203

101203

Parent Item: D350-636-014

D350-636-014

Parent Item Name: Skidtube RH

Start Date: 5/3/2013

Required Date: 5/17/2013

Start Qty: 1.00

Required Qty: 1.00

NAS1611-005

Purchased

No

230

Each

160.0000

8

8

NAS1611-005

O-RING

**

u 13/06/0c

Location

Loc Qty

Loc Code

FP001

110

106099

18

114220

14

122441

55

122538

23

FP002

50

123900

50

x8

NAS1611-010

Purchased

No

230

Each

597.0000

8

8

NAS1611-010

O-RING

**

u 13/06/0c

Location

Loc Qty

Loc Code

FP001

597

110915

14

117460

8

118077

1

118612

3

119438

7

121259

2

121584

2

121723

7

122151

8

123348

29

123352

4

124580

12

125484

500

x8

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8 7 6 5 4 3 2 1

| QTY -041 | QTY -042 | QTY -043 | QTY -044 | PART NUMBER | DESCRIPTION |
|-------------|-------------|-------------|-------------|---------------|--|
| X | | | | D2750-041 | 350 SKIDTUBE ASSEMBLY, LH |
| | X | | | D2750-042 | 350 SKIDTUBE ASSEMBLY, RH |
| | | X | | D2750-043 | 350 SKIDTUBE ASSEMBLY, LH |
| | | | X | D2750-044 | 350 SKIDTUBE ASSEMBLY, RH |
| 1 | 1 | 1 | 1 | D2739 | WEB |
| 8 | 8 | 8 | 8 | D2743 | SPACER |
| 1 | 1 | 1 | 1 | D2744 | CAP |
| 8 | 8 | 8 | 8 | D2745 | BUSHING |
| 1 | | | | D2750-1 | SKIDTUBE WELDMENT, LH |
| | 1 | | | D2750-2 | SKIDTUBE WELDMENT, RH |
| | | 1 | | D2750-3 | SKIDTUBE WELDMENT, LH |
| | | | 1 | D2750-4 | SKIDTUBE WELDMENT, RH |
| 1 | | 1 | | D3488-041 | BLADE FITTING, LH |
| | 1 | | 1 | D3488-042 | BLADE FITTING, RH |
| 4 | 4 | 4 | 4 | D3490-1 | SPACER |
| 4 | 4 | | | D3490-3 | SPACER |
| | | 4 | 4 | D3490-5 | SPACER |
| 8 | 8 | 8 | 8 | D3492-041 | PLUG ASSEMBLY |
| 8 | 8 | | | D3492-043 | PLUG ASSEMBLY |
| | | 8 | 8 | D3492-045 | PLUG ASSEMBLY |
| 1 | 1 | 1 | 1 | D3535-25 | WEARSHOE |
| 1 | 1 | 1 | 1 | D3536-25 | GASKET |
| 3 | 3 | 3 | 3 | D3537-1 | WEARPAD |
| 8 | 8 | 8 | 8 | D3631-1 | WASHER |
| 1 | 1 | 1 | 1 | D3791-1 | WEARPLATE |
| 1 | 1 | 1 | 1 | D3793-1 | WEARSHOE |
| 1 | 1 | 1 | 1 | D3793-3 | WEARSHOE |
| 1 | 1 | 1 | 1 | D3794-1 | GASKET |
| 1 | 1 | 1 | 1 | D3794-3 | GASKET |
| 38 | 38 | 38 | 38 | ALS4-1032-225 | INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225) |
| 34 | 34 | 34 | 34 | AN3C5A | BOLT |
| 4 | 4 | 4 | 4 | AN3C6A | BOLT |
| 4 | 4 | 4 | 4 | AN6C44A | BOLT |
| 1 | 1 | 1 | 1 | AN8C35A | BOLT |
| 38 | 38 | 38 | 38 | AN960C10L | WASHER |
| 1 | 1 | 1 | 1 | AN960C816L | WASHER |
| 4 | 4 | 4 | 4 | MS21043-6 | NUT |
| 1 | 1 | 1 | 1 | MS21083C8 | NUT |
| 4 | 4 | 4 | 4 | NAS1515H3L | WASHER |

GENERAL NOTES:

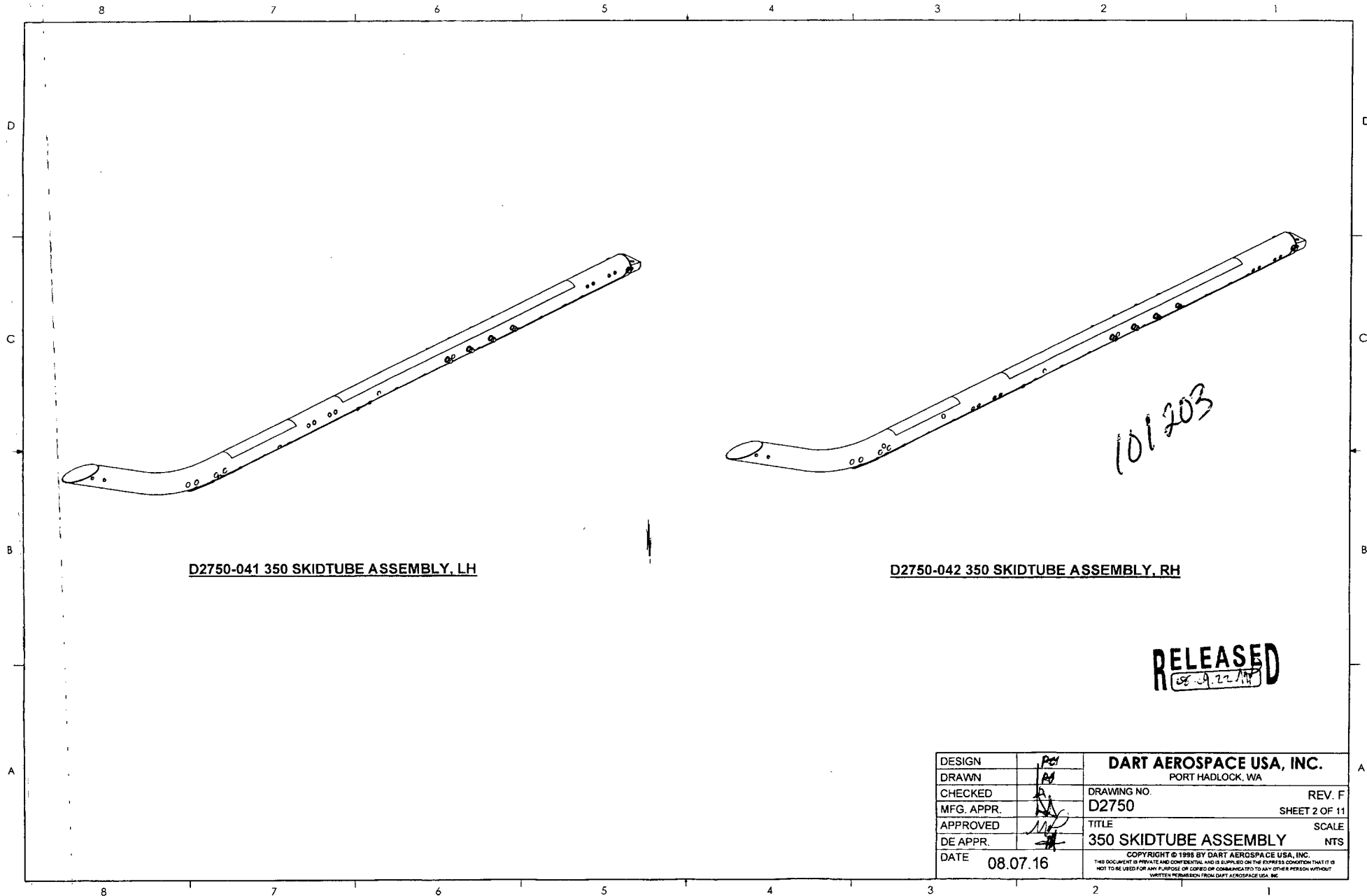
- MATERIAL: MAKE D2750-1/2/3/4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- FINISH: ACID ETCH, ALONDE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: N/A
- WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- WELD PER DART QSI 004
- INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES (Ø0.297) FOR WEARSHOE INSERTS
- FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS.
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF
POWDER COATING WITH MEK DEGREASER.
- SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

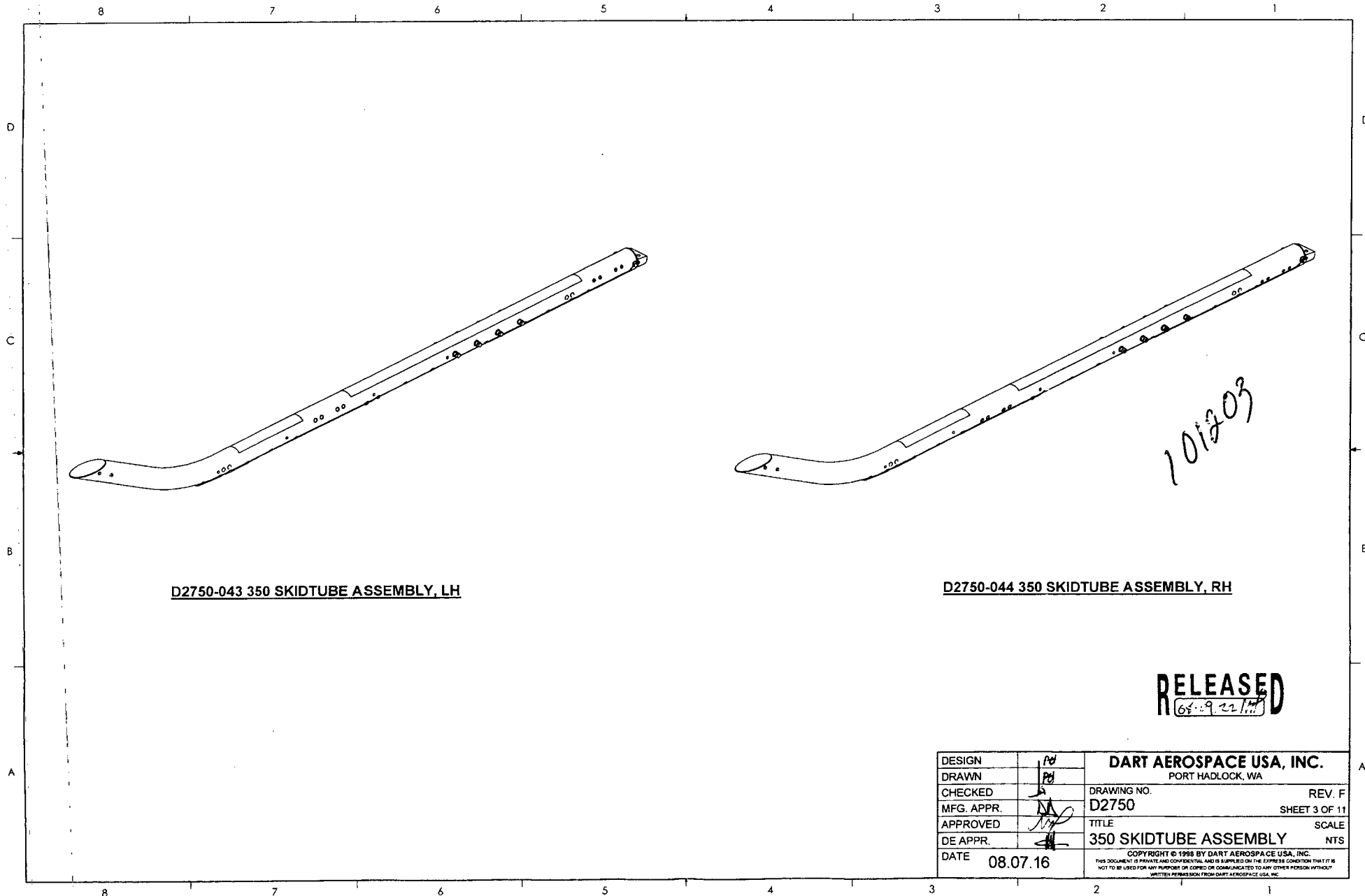
101 203
013-05-3

RELEASED

| | | | |
|------------|---|------|----------|
| F | INCORPORATE DSI 9413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/3 REPLACES D3535-13/35 (ZN C8-1); D3794-1/3 REPLACES D3536-13/35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL). WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 08-043 | PH | 08.07.16 |
| E | CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS; CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515HBL; REMOVE D2741, QTY (2) AN960C816; REMOVE QTY (2) MS21083C8 | CB | 07.05.17 |
| D | ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEO 9133/8157 | PH | 06.01.05 |
| C | ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740 | CP | 98.11.18 |
| B | CHANGE MS24694-S293 TO AN8-16A | CP | 98.09.01 |
| A | NEW ISSUE | DS | 98.04.16 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | PORT HADLOCK, WA | DATE | 08.07.16 |
| DRAWN | DART AEROSPACE USA, INC. | DATE | 08.07.16 |
| CHECKED | DART AEROSPACE USA, INC. | DATE | 08.07.16 |
| MFG. APPR. | DART AEROSPACE USA, INC. | DATE | 08.07.16 |
| APPROVED | DART AEROSPACE USA, INC. | DATE | 08.07.16 |
| DE APPR. | DART AEROSPACE USA, INC. | DATE | 08.07.16 |
| DATE | 08.07.16 | DATE | 08.07.16 |

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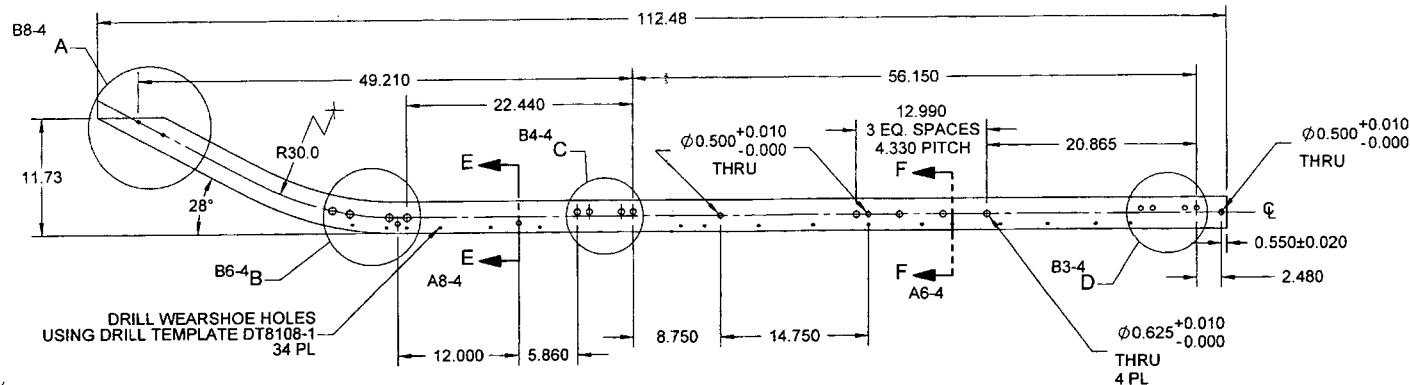




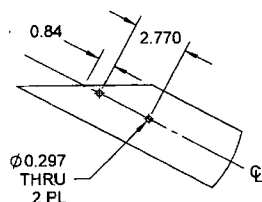
101803

RELEASED
68-9-22/111

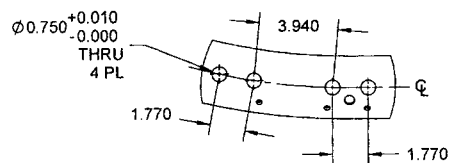
| | | | |
|------------|----------|---|---------------|
| DESIGN | | DART AEROSPACE USA, INC. | |
| DRAWN | | PORT HADLOCK, WA | |
| CHECKED | | DRAWING NO. | REV. F |
| MFG. APPR. | | D2750 | SHEET 3 OF 11 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | 350 SKIDTUBE ASSEMBLY | NTS |
| DATE | 08.07.16 | <small>COPYRIGHT © 1988 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small> | |



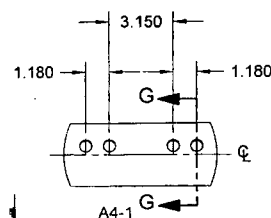
D2750-1 LH SKIDTUBE



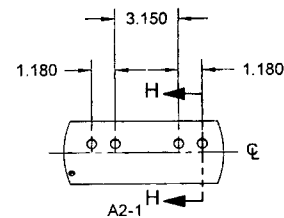
DETAIL A
SCALE 2X



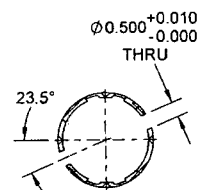
DETAIL B
SCALE 2X



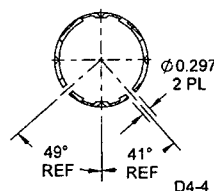
DETAIL C
SCALE 2X



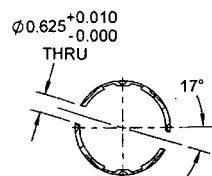
DETAIL D
SCALE 2X



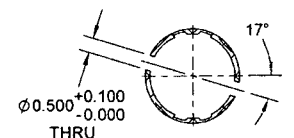
SECTION E-E
SCALE 3X, 2 PL



SECTION F-F
SCALE 3X, 17 PL



SECTION G-G
SCALE 3X, 4 PL



SECTION H-H
SCALE 3X, 4 PL

| | |
|------------|----------|
| DESIGN | 101203 |
| DRAWN | 101203 |
| CHECKED | 101203 |
| MFG. APPR. | 101203 |
| APPROVED | 101203 |
| DE APPR. | 101203 |
| DATE | 08.07.16 |

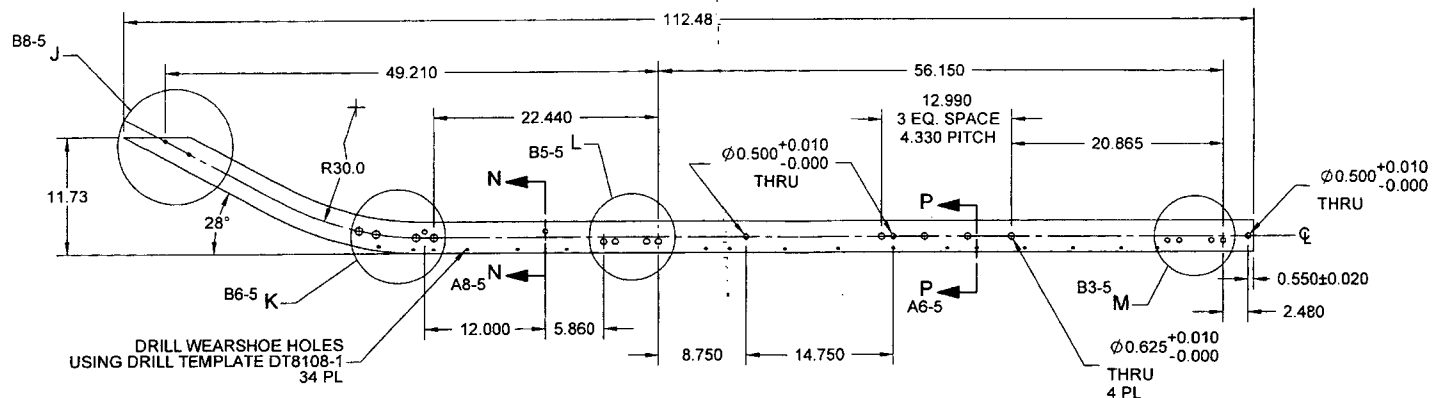
DART AEROSPACE USA, INC.
PORT HADLOCK, WA

DRAWING NO. **D2750** REV. F
SHEET 4 OF 11
TITLE **350 SKIDTUBE ASSEMBLY** SCALE NTS

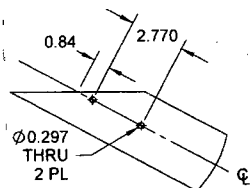
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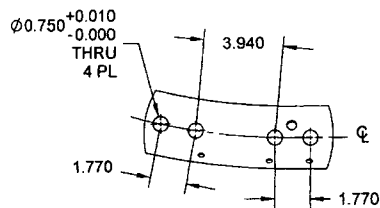
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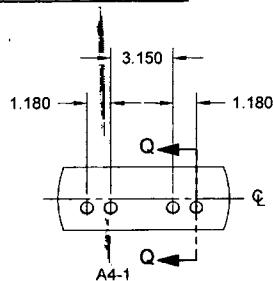
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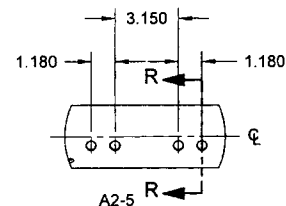
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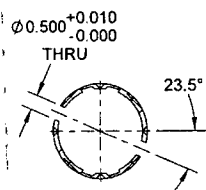
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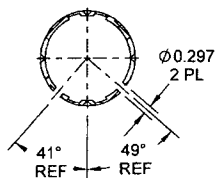
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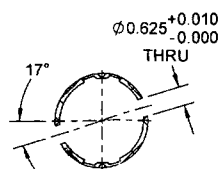
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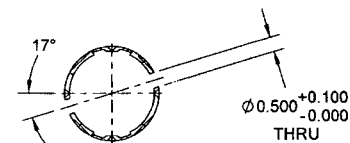
SECTION N-N
SCALE 3X, 2 PL



SECTION P-P
SCALE 3X, 17 PL



SECTION Q-Q
SCALE 3X, 4 PL



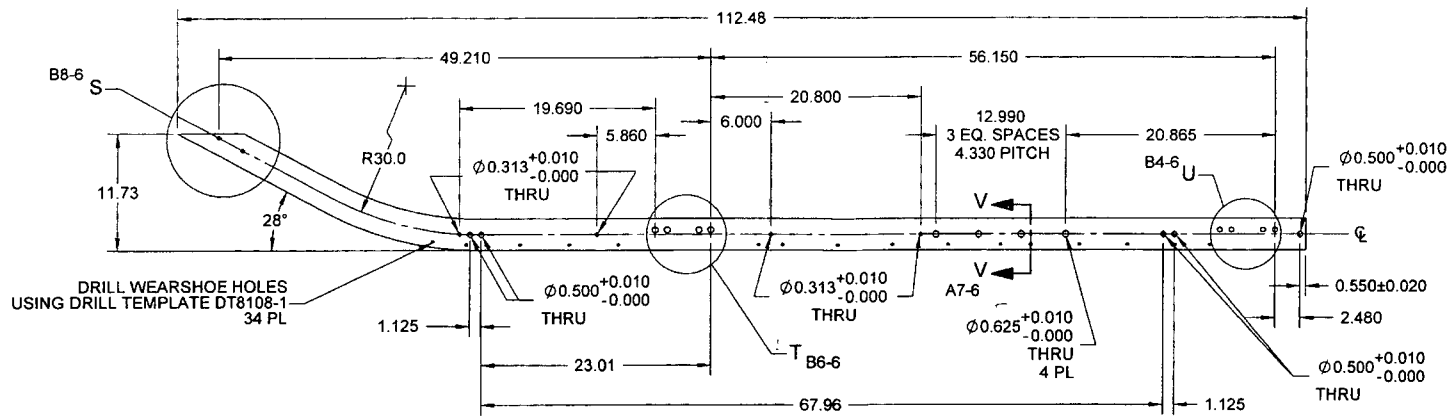
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| DESIGN | REV | DART AEROSPACE USA, INC. | |
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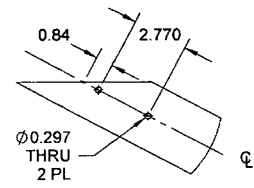
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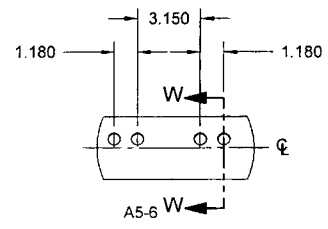
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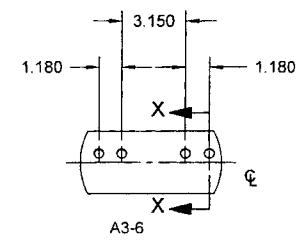
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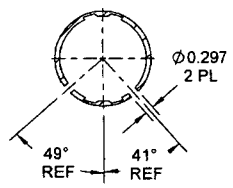
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D8-6
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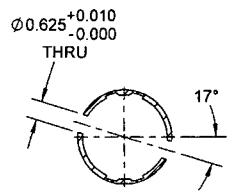
DETAIL T
C5-6
SCALE 2X



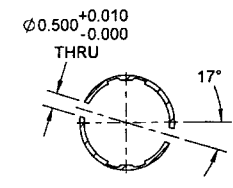
DETAIL U
D3-6
SCALE 2X



SECTION V-V
C4-6
SCALE 3X, 17 PL



SECTION W-W
B6-6
SCALE 3X, 4 PL



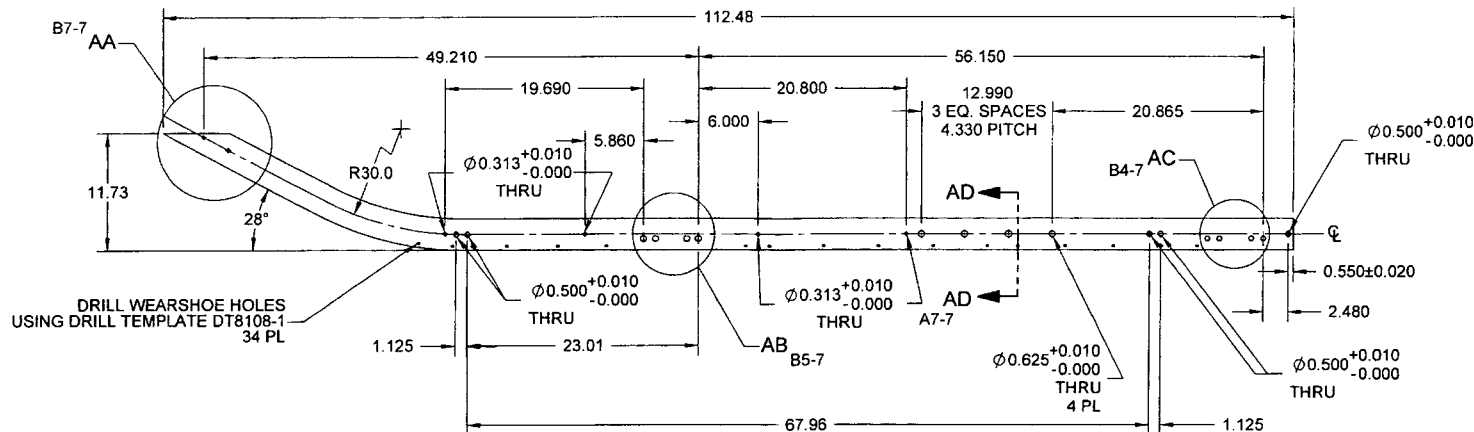
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B4-6
SCALE 3X, 4 PL

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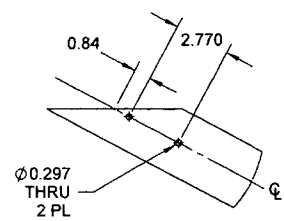
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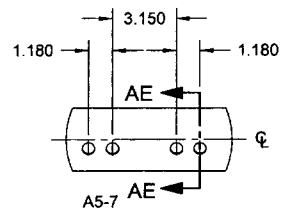
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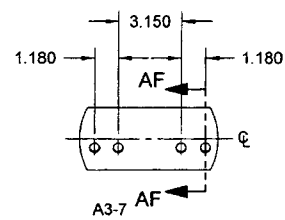
D2750-4 RH SKIDTUBE



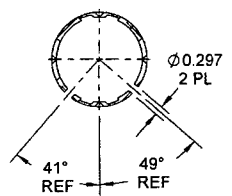
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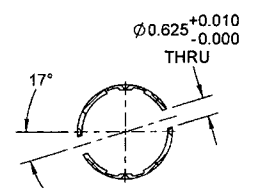
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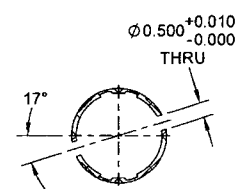
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SCALE 2X



SECTION AD-AD
SCALE 3X, 17 PL



SECTION AE-AE
SCALE 3X, 4 PL

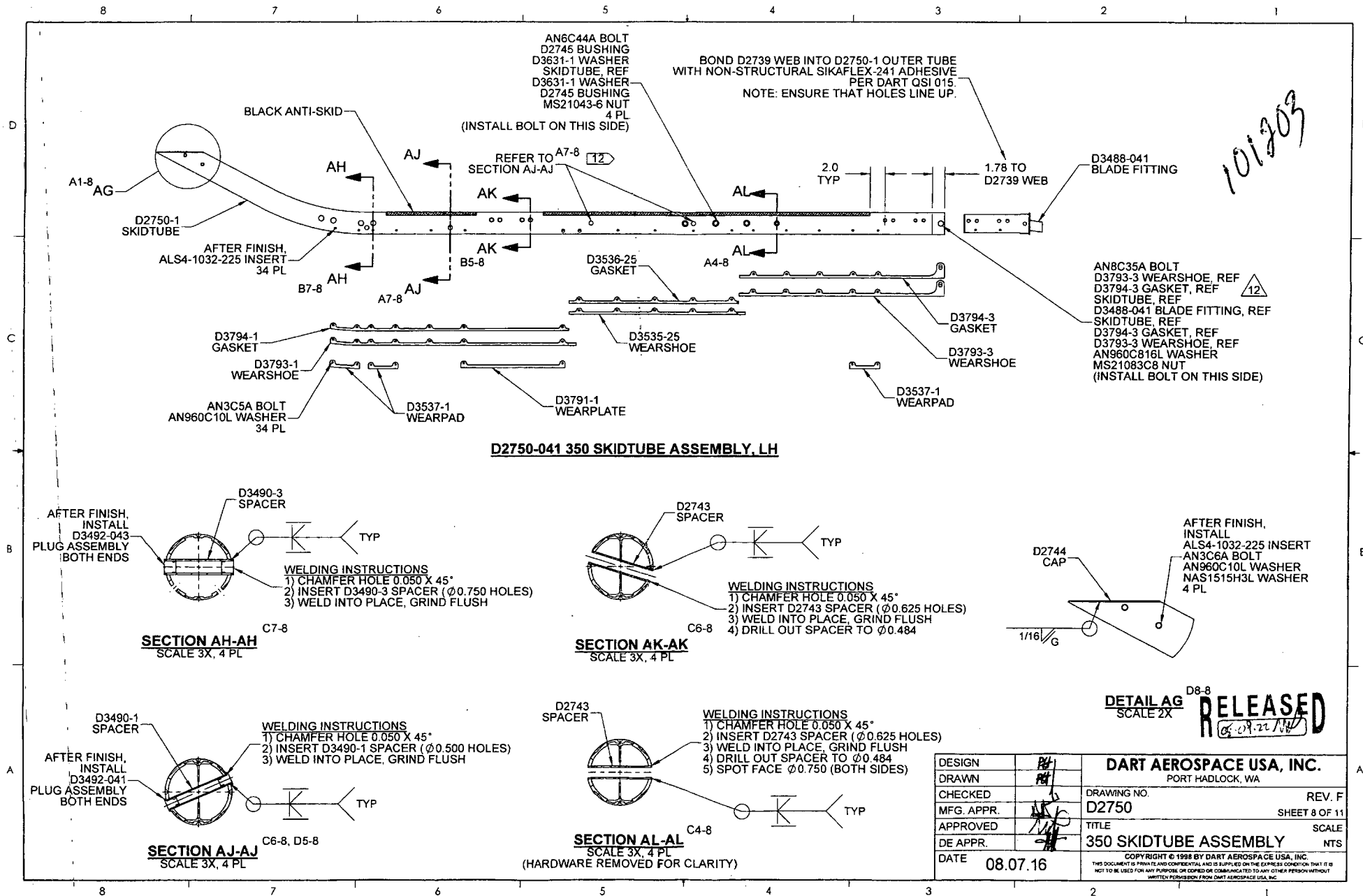


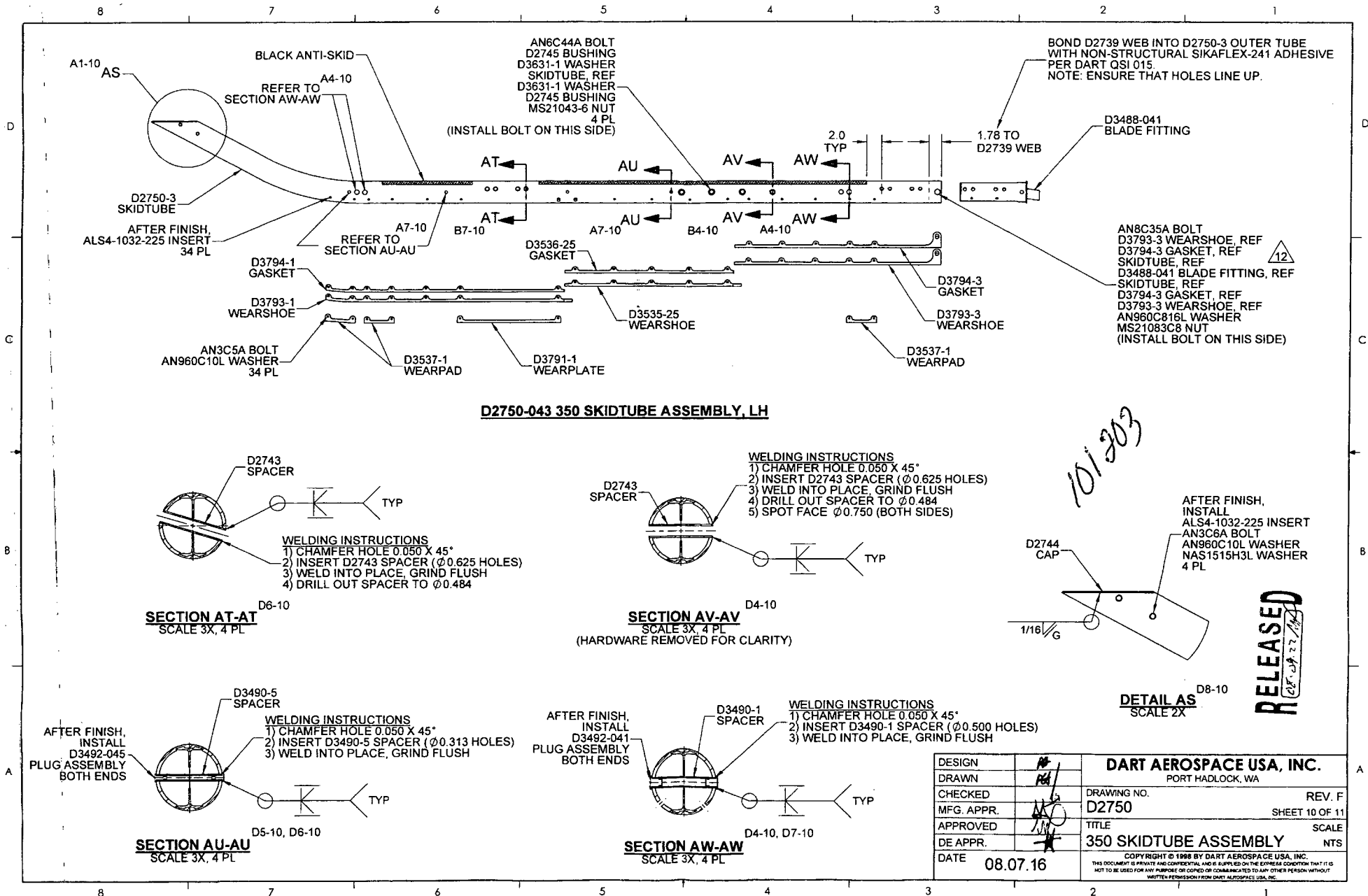
SECTION AF-AF
SCALE 3X, 4 PL

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NO. 321

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job #: 99912
Part #: D350-636-013
Description: 350 skid tube
Welding Process: Tig Mig ☐
Base material: Aluminum
Current: AC ☒ DC ☐

TEST REQUIREMENTS AND RESULTS

| | | |
|-------------------------|--|-------------------------------|
| Visual: | pass <input checked="" type="checkbox"/> | fail <input type="checkbox"/> |
| Incomplete Penetration: | pass <input checked="" type="checkbox"/> | fail <input type="checkbox"/> |
| Incomplete Fusion: | pass <input checked="" type="checkbox"/> | fail <input type="checkbox"/> |
| Cracks: | pass <input checked="" type="checkbox"/> | fail <input type="checkbox"/> |
| Overlap (cold lap): | pass <input checked="" type="checkbox"/> | fail <input type="checkbox"/> |
| Undercut: | pass <input checked="" type="checkbox"/> | fail <input type="checkbox"/> |
| Pin holes: | pass <input checked="" type="checkbox"/> | fail <input type="checkbox"/> |
| Porosity (surface): | pass <input checked="" type="checkbox"/> | fail <input type="checkbox"/> |
| Coloration: | pass <input checked="" type="checkbox"/> | fail <input type="checkbox"/> |
| Burn through: | pass <input checked="" type="checkbox"/> | fail <input type="checkbox"/> |

Qualifier (DAS) 09 Date of Test Coupon 13-05-14

Welder Barclay Elliott Date of Test Coupon 13-05-14

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

Work Order ID 101203

Friday, May 03, 2013 1:27:32 PM

101203

Page 1

Item ID: D350-636-014

Revision ID:

Item Name: Skidtube RH

Start Date: 5/3/2013 Start Qty: 1.00

Required Date: 5/17/2013 Req'd Qty: 1.00

Reference:

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Approvals: Process Plan:

QC:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Draw Nbr Revision Nbr

D2750 F

D3492 C

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

DOCUMENT CONTROL

100

DC

Document Control

Memo

Photocopy blue file and type labels per PPP D350-636-014 CHG 006

MS 13-0612